

152740

Page 1

N9000401 00

Setup Start *NS1*

Stop ***NS2***

12

12

Approvals: Process Plan: VS / DAS Date: 16/11/8
QC: 21 Date: 9-89

Date:

Run Start *NR1*

Date:

Stop *NR2*

**Insp.
Stamp**

DAS

45 /

9-89

DAS

45

45
0.00

9-89

DAS

451

45 1
0.00

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 152740***152740***

Page 2

Monday, November 07, 2016 3:04:34 PM

Item ID: D2858-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Bracket
Start Date: 11/4/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/17/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04				12	✓		DAS 49 9-89 16/11/15
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.02				(X12)	✓		2016/11/15 BEB
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 134798 Memo START TIME: 9:10 FINISH TIME: 9:40	0.00 0.02				12	✓	16-11-15	DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Page 3

Monday, November 07, 2016 3:04:34 PM

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge Bracket

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.02

Quality Control

DAS
38
9-89
NOV 15 2016

170

Identify as per dwg & Stock Location: Store

0.00

170

Packaging

Memo

0.02

Packaging

12

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.20

Quality Control

DAS
21
9-59

NOV 18 2016

DAS
21
9-59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, November 07, 2016 3:04:37 PM

Page 1

Work Order ID: 152740

152740

Parent Item: D2858-1

D2858-1

Parent Item Name: Hinge Bracket

Start Date: 11/4/2016

Required Date: 11/17/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	17.9480	0.163	2.058947			

M6061T6B1 500X01 250

6061-T6 Bar 1.50 x 1.25

Location

MAT003

m134158

m135987

Loc Qty

17.948

5.948

12

Loc Code

1,750
+500

2,250 ft

DAS
45 11/11/14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Root Cause				FAULT CATEGORY																																																																					
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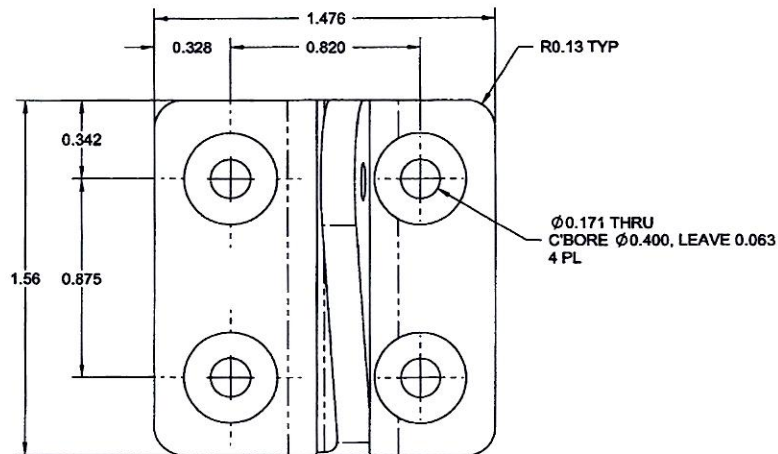
DART AEROSPACE LTD		Work Order:	152740
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

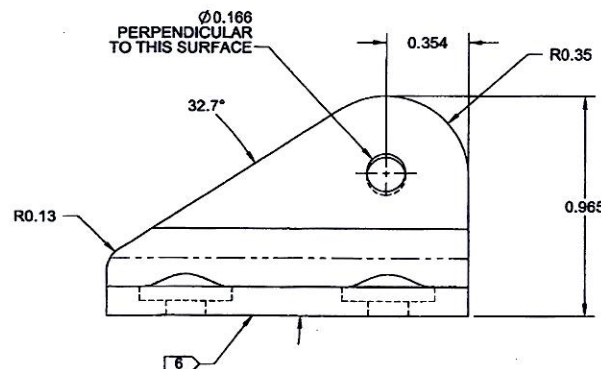
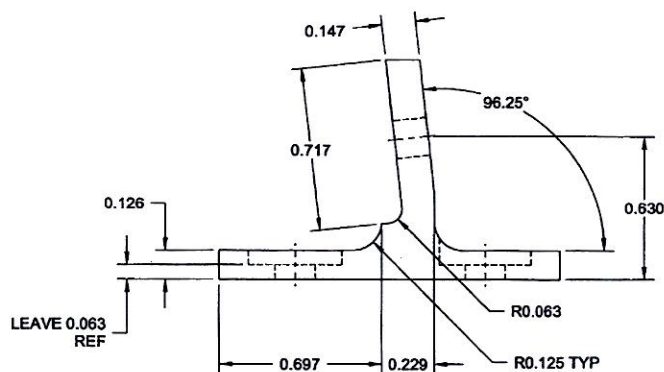
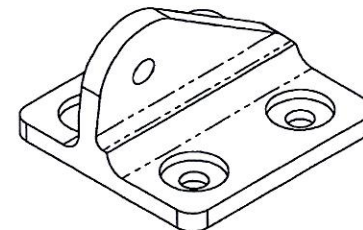
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	0.173	✓		Caliper	OK-01
Ø0.400	+0.006/-0.001	0.400	✓		✓	✓
R0.125	+/-0.010	r.125	✓		rad G	Shp
0.328	+/-0.010	0.327	✓		caliper	OK-01
0.820	+/-0.005	0.820	✓			
1.476	+/-0.010	1.474	✓			
0.342	+/-0.010	0.342	✓			
0.875	+/-0.005	0.874	✓			
1.56	+/-0.030	1.562	✓			
0.147	+/-0.010	0.150	✓			
0.717	+/-0.010	0.716	✓			
0.697	+/-0.010	0.697	✓		HL	Block
0.229	+/-0.010	0.231	✓		caliper	OK-01
R0.125	+/-0.010	r.125	✓		rad G	Shp
R0.063	+/-0.010	r.063	✓		✓	✓
0.063	+/-0.010	0.066	✓		micr	OK-02
0.126	+/-0.010	0.129	✓		micr	✓
0.630	+/-0.010	0.631	✓		caliper	OK-01
R0.354	+/-0.010	r.354	✓		rad G	Shp
0.965	+/-0.010	0.968	✓		caliper	OK-01
Ø0.166	+0.005/-0.001	0.169	✓		✓	✓
R0.125	+/-0.010	r.125	✓		rad G	Shp
32.7°	+/-0.5°	32.7°	✓		edge G	Shp

Measured by:	DAS 45 9-89	Audited by:	DAS 49 9-89	Preliminary Approval:	
Date:	16-11-14	Date:	16/11/15	Date:	

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	
B	11.11.07	Dwg Rev updated	KJ	



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NO. 152740



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD, REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1, A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

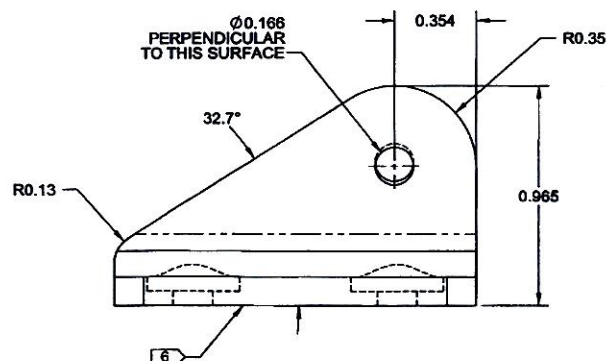
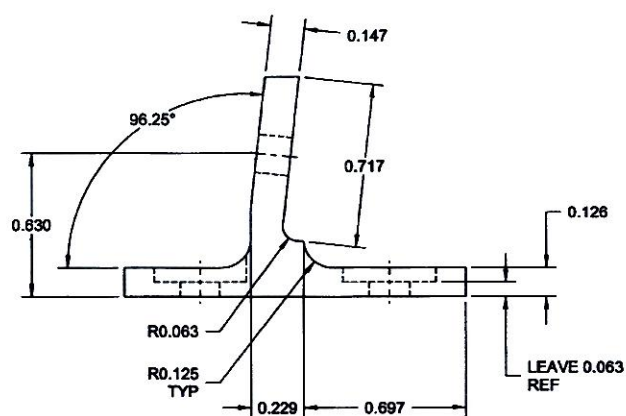
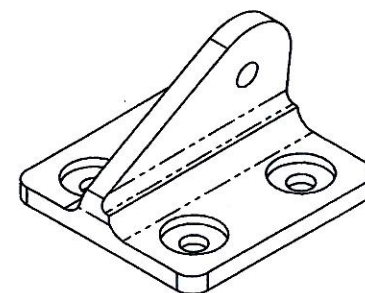
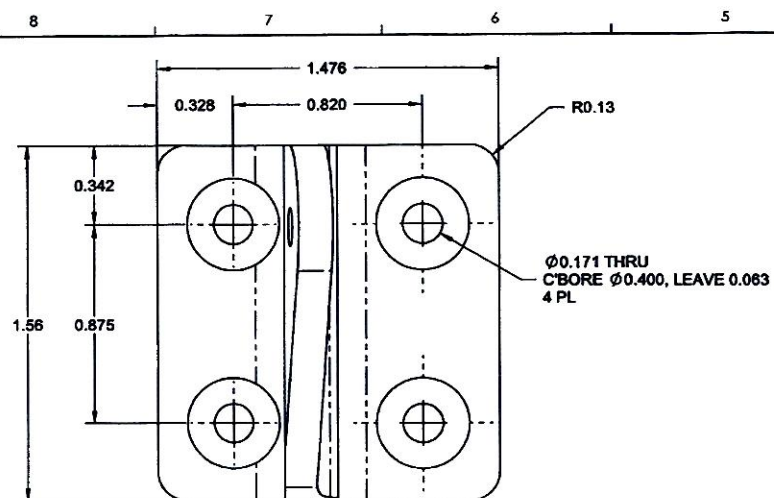
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2858

TITLE
HINGE BRACKET

REV. C
SHEET 1 OF 2
SCALE
NTS

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D2858-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART PIN "D2858-2" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2858	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1988 BY DART AEROSPACE LTD	
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2010-11-26